

Date: Tuesday, 15/07/2008 4:11:58 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
Job Number :	40514	Part Number :	D2571	
Estimate Number :	10530	Drawing Number :	D2571 REV E	
P.O. Number :		Project Number :	N/A	
This Issue :	15/07/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	E	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	39806	Material :		
Written By :		Due Date :	08/08/2008	Qty: 10 Um: Each
Checked & Approved By :	<u>JUL 08.7.16</u>			
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: 834875

ml 08/08/13

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 40514 Double check by: JA

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

(PTO)

ml / J.F. 08/08/15 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

J.F. 08/08/15 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/15 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2571 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 0 Date: 08.08.27
D412-742-03/011 QA: N/C Closed: D Date: 09/08/26

NCR: <u>40514</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/13	2.0	1 part scrap, the skid bolt pattern too thin. R.C. the part start to vibrate	<u>Resman</u>	scrap and destroy and replace Qty: 1 Batch: <u>34875</u>	<u>mb</u> 08/08/13	<u>08/08/13</u>	<u>Resman</u>	<u>S</u> 08/08/13

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40514

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/08/19 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M2 08/08/19 (10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:45

OVEN TEMPERATURE:

320°C

FINISH TIME:

12:15

M-L 08/08/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BP 08-08-19 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 21 432

CL 08/08/21 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40514
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	φ.439	φ.439	φ.439"		
B	1.745	1.755		1.750	S	1.749"	1.750"		
C	3.495	3.505		3.500	C	3.501"	3.501"		
D	1.745	1.755		1.750	C	1.744"	1.750"		
E	7.990	8.010		8.000	R	8.005"	8.005"		
F	0.490	0.510		.502	A	.502"	.504"		
G	0.257	0.262		.258	.259	.260	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.498	.499	.498		
J	1.174	1.184		1.177	1.178	1.179	1.178		
K	0.558	0.578		.565	.566	.565	.563		
L	1.174	1.184		1.177	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.870	3.874	3.873		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.130	.132	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.959	2.960	2.960		
V	0.230	0.250		.240	.240	.238	.238		
W	0.115	0.135		.120	.123	.122	.122		
X	0.308	0.313		.309		.309"	.309"		
Y	0.760	0.765		.760		.760"	.760"		
Z	0.352	0.372		.363		.363"	.370"		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.631		.635"	.630"		
AC	0.053	0.073		.063		.063"	.063		
AD	0.240	0.260		.245	.247	.246	.247		
AE	1.375	1.395		1.387	1.387	1.390	1.390		
AF	0.115	0.135		.130	.132	.131	.131		
AG	0.240	0.280		.260	.260	.266	.260		
AH	0.240	0.260		.250	.249	.247	.246		
AI	2.000	2.020		2.000	2.000	2.004	2.005		
AJ	0.023	0.043		.033	.033"	.033"	.033"		
Accept/Reject									

Measured by: <i>J.F.</i>
Date: 08/08/13

Audited by: <i>JP</i>
Date: 08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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WITHOUT NOTICE
WORK ORDER
NO. _____

DART AEROSPACE LTD	Work Order: 40514
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443	0	0.439"	0.439"	0.439"	0.439"		
B	1.745	1.755		1.749"	1.749"	1.749"	1.749"		
C	3.495	3.505		3.501"	3.501"	3.501"	3.501"		
D	1.745	1.755		1.749"	1.749"	1.749"	1.749"		
E	7.990	8.010		8.005"	8.005"	8.005"	8.005"		
F	0.490	0.510		0.505"	0.510"	0.508"	0.510"		
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
H	0.375	0.380		0.376"	0.377"	0.377"	0.377"		
I	0.490	0.510		0.500"	0.502"	0.503"	0.503"		
J	1.174	1.184		1.182"	1.182"	1.182"	1.182"		
K	0.558	0.578		0.562"	0.566"	0.567"	0.565"		
L	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
M	1.490	1.500		1.499"	1.499"	1.499"	1.499"		
N	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		0.126"	0.126"	0.126"	0.126"		
Q	0.115	0.135		0.127"	0.127"	0.127"	0.127"		
R	0.240	0.260		0.252"	0.250"	0.252"	0.250"		
S	0.115	0.135		0.130"	0.130"	0.130"	0.135"		
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
U	2.940	2.980		2.959"	2.959"	2.959"	2.959"		
V	0.230	0.250		0.241"	0.241"	0.242"	0.241"		
W	0.115	0.135		0.122"	0.122"	0.124"	0.123"		
X	0.308	0.313		0.308"	0.309"	0.311"	0.311"		
Y	0.760	0.765		0.760"	0.760"	0.760"	0.760"		
Z	0.352	0.372		0.372"	0.372"	0.372"	0.372"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.633"	0.633"	0.632"	0.632"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.260"	0.260"	0.250"	0.250"		
AE	1.375	1.395		1.390"	1.389"	1.390"	1.389"		
AF	0.115	0.135		0.125"	0.125"	0.125"	0.125"		
AG	0.240	0.280		0.246"	0.246"	0.246"	0.246"		
AH	0.240	0.260		0.250"	0.250"	0.249"	0.248"		
AI	2.000	2.020		2.005"	2.005"	2.004"	2.004"		
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"		
Accept/Reject									

Measured by: J.F.
Date: 08/08/15

Audited by: [Signature]
Date: 08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]


DART AEROSPACE LTD	Work Order: 40514
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:







				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
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B	1.745	1.755		1.749"	1.749"	1.749"			
C	3.495	3.505		3.501"	3.501"	3.501"			
D	1.745	1.755		1.749"	1.749"	1.749"			
E	7.990	8.010		8.005	8.005	8.005			
F	0.490	0.510		0.504"	0.504"	0.504"			
G	0.257	0.262		0.258"	0.258"	0.258"			
H	0.375	0.380		0.377"	0.377"	0.377"			
I	0.490	0.510		0.504"	0.504"	0.504"			
J	1.174	1.184		1.182"	1.182"	1.182"			
K	0.558	0.578		0.575"	0.575"	0.575"			
L	1.174	1.184		1.180"	1.180"	1.180"			
M	1.490	1.500		1.499"	1.499"	1.499"			
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V	0.230	0.250		0.241"	0.242"	0.241"			
W	0.115	0.135		0.121"	0.121"	0.121"			
X	0.308	0.313		0.310"	0.310"	0.310"			
Y	0.760	0.765		0.760"	0.760"	0.760"			
Z	0.352	0.372		0.372"	0.372"	0.372"			
AA	0.470	0.530		0.500"	0.500"	0.500"			
AB	0.615	0.635		0.633"	0.633"	0.625"			
AC	0.053	0.073		0.063"	0.063"	0.063"			
AD	0.240	0.260		0.250"	0.250"	0.250"			
AE	1.375	1.395		1.389"	1.390"	1.391"			
AF	0.115	0.135		0.125"	0.125"	0.125"			
AG	0.240	0.280		0.246"	0.246"	0.246"			
AH	0.240	0.260		0.248"	0.248"	0.248"			
AI	2.000	2.020		2.004"	2.004"	2.005"			
AJ	0.023	0.043		0.033"	0.033"	0.033"			
Accept/Reject									

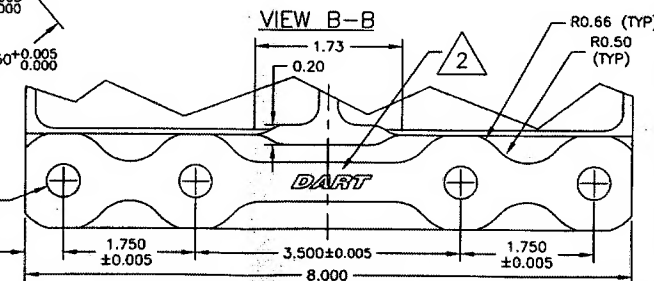
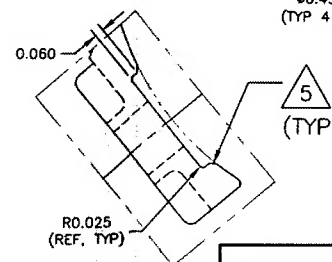
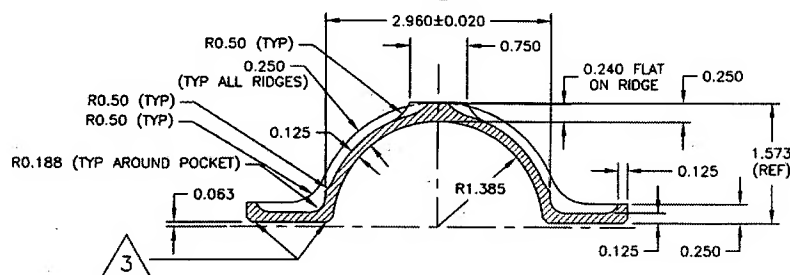
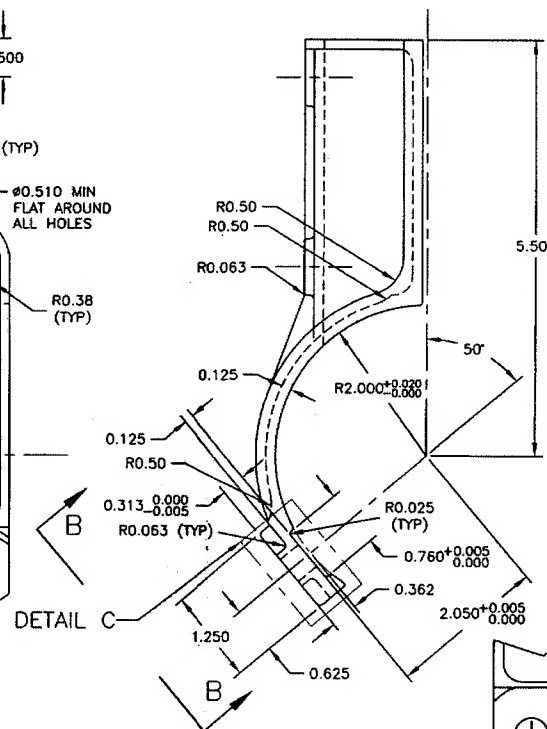
Measured by: J.T.	Audited by: [Signature]
Date: 08/08/15	Date: 08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

05.12.06. 

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN		DRAWN BY		NEW 1000E	
DS		PH		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV.	
#	#	D2571		SHEET 1 OF	
DATE		TITLE			
05.07.13		OUTER FWD SADDLE			
		SCALE			

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